		***************************************										
Work Orde Tuesday, August												Page 1
Item ID:	D3391-021			Accept					Setup	Start		
Item Name:	Fwd Tube Ass	embly				•				Stop		
Start Date: Required Date:	8/31/2010 9/7/2010	Start Qty: 1.00 Req'd Qty: 1.00			Cust Item II Customer:	D;						
Reference:									Б.	644		
Approvals:	Process Plan	n:	Date/0-8-3/			ite:		,	Run	Start Stop		
	QC:		Date:	<b>SPC (Y/N):</b>	Da	ite:				r		
Sequence ID/ Work Center II	)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
Draw Nbr	Revi	ision Nbr										
D3391	Rev	Н				<u> </u>			-			
Skidtubes Skidtubes	·	Skidtubes  Memo Cut extru	usion to 46.52 +0.010 -0.020	0.00					<del></del>			. ;
110				0.00		7<			) ,			
	•	BENDING MACHIN	E - SKIDTUBES			\		7		0	-9	1-27
CNC Bend 1 CNC Delta 100 Bend	der	Memo Bend as p	per Dwg D3391 Using Bend P	0.00 rog 3391021						•		
120		QC5- Inspect part con	npleteness to step on W/O	0.00								

QC

Memo

0.00

Quality Control



Dart Ae	rospace	Ltd							t
W/O:		AA	V	VORK ORDER CHANGE	S				
DATE	STEP	PRO	OCEDURE CH	IANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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<b></b>									
Part No	-	PAR #:	Fault Ca	NCR: Yes	No DQ	٩:	Date:		
	Re	esolution:	Disposit	ion:	QA: N/C CI	osed:		Date: _	
NCR:		\	NORK OR	DER NON-CONFORMA	NCE (NCF	l)			
D.475	0777	Description of NC		Corrective Action Section		Verific	ation	Approval	Approvai
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		Chief Eng	QC Inspector
				-					

#### Work Order ID 61662

Tuesday, August 31, 2010 10:42:37 AM



Page 2

Item ID:

D3391-021

Accept

Tool # Plan

Code

Setup Start

**Revision ID:** 

**Start Date:** 

Item Name:

Required Date: 9/7/2010

Fwd Tube Assembly

8/31/2010

Start Qty: 1.00

**Req'd Qty:** 1.00

**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Accept

Qty

Start

Stop



Date:\_\_\_\_

SPC (Y/N):

Date:

**Tool ID** 

Stop

Reject

Qty



Number Stamp

Insp.

Reject

Sequence ID/ **Work Center ID** 

130

HAAS 1

HAAS CNC vertical machine #1

Operation Description Set Up/ **Run Hours** 

0.00

HAAS CNC VERTICAL MACHINING #1

Memo

0.00

1-Machine as per Folio FA590 Rev. & Dwg D3391 Rev.

Identify as D3391-1

2-Deburr

Memo

140

QC

Quality Control

OC2- Inspect parts off machine FAI/FAIB

0.00

0.00

10/11/15

150

Mill Conv

CONVENTIONAL MILLING MACHINE

Memo

0.00

0.00

Conventional Milling Machine

Drill X1 Aft cap as per Dwg D3391 .1875" dia

10/11/17

W/O:		WORK ORDER O	WORK ORDER CHANGES									
DATE STE		PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector					
	and the state of t											
x.												
Part No	•	PAR #: Fault Category:	NCR: Yes	No <b>DQ</b>	A:	Date:						

NCR:			WORK ORDER NON-CONFORMANCE (NCR)												
		Description of NC		Corrective Action Section B		Verification	Approval	Approval							
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector							
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#### Work Order ID 61662

Tuesday, August 31, 2010 10:42:37 AM



Page 3

Item ID: Revision ID: Item Name:

D3391-021

Fwd Tube Assembly

8/31/2010 **Start Date:** Required Date: 9/7/2010

Start Oty: 1.00 Req'd Qty: 1.00

Accept

Setup Start

Stop

**Cust Item ID: Customer:** 

Reference:

Approvals:

Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Tool ID

Date:

Tool # Plan

Code

Start Run

Reject

Qty



Insp.

Stamp

Stop

Reject

Number

Sequence ID/ **Work Center ID** 

160

Quality Control

Operation Description

QC2- Inspect parts off machine FAI/FAIB

Set Up/ **Run Hours** 

0.00

0.00

90/11/17

Qty

Accept

170

Quality Control

QC8- Inspect parts - second check

Memo

Memo

0.00

0.00

Dart Aero	space	Ltd
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W/O:			WC	ORK ORDER CHANG	ES					
DATE	STEP	PR	ROCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector
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Part No		PAR #:	Fault Cate	gory:	NCR:	Yes N	lo DQA		Date:	
	R	esolution:	Disposition	n:	_ QA: 1	VC Clo	sed:		Date: _	<del></del> .
NCR:			WORK ORDI	ER NON-CONFORMA	NCE	(NCR)				
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DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Section		Chief Eng	QC Inspector
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#### Work Order ID 61662

Tuesday, August 31, 2010 10:42:37 AM



Page 4

Item ID:

D3391-021

Accept

Setup Start

Stop



**Revision ID:** 

Item Name:

Fwd Tube Assembly

**Start Date:** 

8/31/2010

Start Qty: 1.00

Required Date: 9/7/2010

Req'd Qty: 1.00



**Cust Item ID:** 

**Customer:** 

Reference:

**Approvals:** 

- Process Plan:

Date:

Tooling:

Date:

Run

Start

Stop



Date:

SPC (Y/N):

Set Up/

**Run Hours** 

**Tool ID** 

Tool # Plan

Date:

Accept Code **Qty** 

BE10/11/30

Reject **Qty** 

Reject Number

Insp. Stamp

**Work Center ID** 180

Sequence ID/

Skidtubes Skidtubes

Description

Skidtubes

Operation

Memo

0.00

0.00

1-Drill float bag holes as per Dwg D3391 using DT8798(Do not open tow cap holes to finish size)

(ONLY DRILL HOLES MARKED "A")

2-Drill Remaining two holes for tow cap using DT 8819 Locating off of .1875" holes drilled in previous step

3-Open tow cap holes to .208" as per Dwg D3391

4-Open Tow Ring hole to .640" as per Dwg D3391

5- open float bag holes 0.328" and counter sink as per dwg D3391

6-Deburr & Scribe Batch number Inside aft end.

7-Transfer drill D3391-021 with D3391-023

11-2-11

Quality Control

Memo

QC5- Inspect part completeness to step on W/O

W/O:	***************************************	WORK ORDER CH	WORK ORDER CHANGES											
DATE STEP		PROCEDURE CHANGE	Ву	y Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector							
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						•								
Part No	<b>:</b>	PAR #: Fault Category:	NCR: Yes	No DQ	۹:	_ Date: _								

Resolution: \_\_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)											
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#### Work Order ID 61662

Page 5

Tuesday, August 31, 2010 10:42:37 AM

Item	ID:
TOWAIL	

D3391-021

Accept



Setup Start



**Revision ID:** 

Item Name:

Fwd Tube Assembly

**Start Date:** 

Required Date: 9/7/2010

8/31/2010

Start Qty: 1.00 Req'd Oty: 1.00

**Cust Item ID:** 

**Customer:** 

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

Stop

Stop



QC:

Date:

SPC (Y/N):

Date:

Reject

Sequence ID/ **Work Center ID** 

200

HandFinish

Description

Operation

Chemical Conversion Coat per QSI005 4.1

0.00

0.00

Set Up/

**Run Hours** 

Tool ID

Code

Tool # Plan

Accept Qty

Reject Qty

Number Stamp

Hand Finishing

210 .

Quality Control

QC3- Inspect Part Finish

Memo

Memo

0.00

0.00

220

Skidtubes Skidtubes Skidtubes

0.00

Memo

1-instal spacers as per dwg D3391 A/R Magnabond 6398 batch: /////
exp. date: 08/20//

cure time 12hrs, as per OSI015

2- grind crossbolt flush 3-back drill crossbolt if necessary

0.00

Dart Ae	rospace	Lia							•
W/O:			WC	RK ORDER CHANG	ES				<i>,</i>
DATE	STEP	PR	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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NCR:			WORK ORDE	ER NON-CONFORMA	ANCE (NCH	)			
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#### Work Order ID 61662

Tuesday, August 31, 2010 10:42:37 AM



Page 6

Item ID:

D3391-021

Accept



Setup Start

Stop



Revision ID:

Item Name:

Fwd Tube Assembly

**Start Date:** 

8/31/2010

Start Qty: 1.00

Required Date: 9/7/2010

Req'd Qty: 1.00



**Cust Item ID:** 

**Customer:** 

**Tool ID** 

Reference:

Approvals:

Process Plan:

Date: Tooling:

Date:\_\_\_\_\_

SPC (Y/N):

Date:

Date:

Run

Reject

Oty

Start Stop



Sequence ID/ **Work Center ID** 

230

Quality Control

**Operation Description** 

QC5- Inspect part completeness to step on W/O

Set Up/ **Run Hours** 

0.00

Tool # Plan Code

Accept Otv

Reject Number

Insp. Stamp

0.00

Sular ry

235

HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

Memo

0.00

Memo

0.00

AND REALODINE AS PER PAR09-043

240

Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

0.00

1 Bl 11-3-16

W/O:			W	ORK ORDER CHANG	ES			
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Revision ID: Item Name:	D3391-021  Fwd Tube Assembly	Ot 100		Accept					Setup	Start Stop		
Start Date: Required Date: Reference:		Qty: 1.00 Qty: 1.00			Cust Item I	ID:				S	1 18811181 8	
Approvals:	Process Plan:		Date:	Tooling:	D	ate:			Run			
	QC:		Date:	SPC (Y/N):	D	ate:				Stop		
Sequence ID/ Work Center IE	Opera Descri			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reje Qty		Reject Number	Insp. Stamp
250    <b>                             </b> QC	QC3- In	spect Part Finish  Memo		0.00						<u> </u>	H i	103/17
Quality Control												·
255				0.00						1	• 1	, (
Skidtubes	Skidtube	Memo		0.00					<del></del>	\$	H	11/03/0

Skidtubes

\*\*\*\* install D3591-1 spacer as per DSI9364 and wearplate and gasket as per DWG \*\*\*\*

QC5- Inspect part completeness to step on W/O

0.00 Julos 117

Quality Control

Memo

W/O:			W	ORK ORDER CHAN	GES					****
DATE	STEP	PRO	OCEDURE CHA	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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#### Work Order ID 61662

Tuesday, August 31, 2010 10:42:37 AM



Page 8

Item ID:

D3391-021

Accept



Setup Start

Stop



**Revision ID:** 

Item Name:

Fwd Tube Assembly

**Start Date:** 

8/31/2010

Start Qty: 1.00

Required Date: 9/7/2010

Req'd Qty: 1.00



**Cust Item ID:** 

**Customer:** 

Tool ID

Reference:

**Approvals:** 

Process Plan:

Date: **Tooling:** 

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/ Work Center ID

260

Packaging

Packaging

**Operation** Description

Identify as per dwg & Stock Location:  $\omega | \mathcal{O}$ 

Date:\_\_\_\_\_

Memo

Set Up/ **Run Hours** 

0.00

0.00

Date:

Tool # Plan Code

Accept Qty

Reject Qty

Reject

Insp. Number Stamp

280

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/3/17 ty

Duit AC	ospace	· I CCI								
W/O:				WORK ORDER (	CHANGES			**		
DATE	STEP	75	PRO	OCEDURE CHANGE	Ву		By Date		Approval Chief Eng / Prod Mgr	Approval QC Inspector
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#### **Picklist Print**

Tuesday, August 31, 2010 10:42:42 AM

Work Order ID: 61662

Parent Item:

D3391-021

Parent Item Name: Fwd Tube Assembly

Start Date: 8/31/2010

Required Date: 9/7/2010

Page 1

Start Qty: 1.00

Required Oty: 1.00

Comments:

IPP A□05.09.13□New issue□

KJ/JLM

IPP B□06.02.10□Dwg rev.D ecn 773 □EC□

IPP C□06.05.02□Added inspections 

IPP D 07.03.13 rev F dwg

EC

IPP E 07.11.07 revG dwg ecn1053P

EC verified by: DD

IPP Rev:f ECN 1056 07-11-12 DD verified by: EC

IPP Rev:G 08-09-08 new process (ecn 08-510) DD verified by:EC

IPP Rev:H 08-09-10 revH as per dwg DD verified by:EC

Manufactured

Manufactured

No

IPP Rev J 09.02.02 added hardware EC verifified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status	
D6013-047		Manufactured	No			100	Each	39.0000		1	,			

Skidtube Material

	Location	Lo	c Oty	Loc Code
	LG		39	
	23935		3	
	(26547)		36	
No		220	Each	64.0000



D3670-4-200	

SPACER

<b>Location</b>	<u>Lo</u>	Loc Oty					
LG		64					
57349		64					
· · · · · · · · · · · · · · · · · · ·	255	Each	12.0000				

D3401-041		
		I
: :	E81   B 88  1 8  18	ı

Tow Cap Assembly

Location	Loc Oty	Loc Code
FP	12	
46029	12	

W/O:		WORK ORDER CHANGES										
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
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Tuesday, August 31, 2010 10:42:42 AM

Work Order ID: 61662

D3391-021

Parent Item Name: Fwd Tube Assembly

NAS1149C0332



Start Date: 8/31/2010

Required Date: 9/7/2010

Start Qty: 1.00

Required Qty: 1.00

1103117

D3564-13

Wearshoe

Parent Item:

No Manufactured

255

Each

19.0000

D3566-13

Manufactured No

Purchased

Location FP17 59660 60862

59661

60209

7 12 255 Each

Loc Qty

19

Loc Code Blelesula

10

Gasket

No

Location

FP012

Loc Oty 22 14 8 255 Each Loc Code 1366137

155.0000

Loc Code

N1 116304

22.0000

10

washer

AN960C10L

Location Loc Oty ST245 155 107534 29 109545 54 111548 72

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W/O:			M	ORK ORDER CHANG	ES					
DATE	STEP	PRO	CEDURE CH	IANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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NCR:		\	WORK OR	DER NON-CONFORMA	ANCE	(NCR)	1			<u> </u>
DATE	STEP	Description of NC		Corrective Action Section	ion B	Verificat		tion	Approval	Approval
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#### **Picklist Print**

Tuesday, August 31, 2010 10:42:42 AM

Page 3

Work Order ID: 61662 Parent Item: D3391-021 Parent Item Name: Fwd Tube Assembly Required Date: 9/7/2010 Start Date: 8/31/2010 Required Qty: 1.00 Start Qty: 1.00 AN3C4A Purchased No 255 Each 1,567.000 10 10 BOLT Location Loc Qty Loc Code 1117010 V10 ST303 500 115438 500 ST350 1067 114108 14 114416 12 114523 2 114941 39 115300 1000 D3672-1 Manufactured 255 Each 917.0000 No nloz Phenolic Washer Location Loc Qty Loc Code ST077 917 42329 150 767 <u>5250</u>5 AELS-1032-130 Purchased No 255 Each 0.0000 M 116864 NOT in INSERT INUC! AELS-1032-225 Purchased 255 Each 0.0000 11110768 INSERT

W/O:			W	ORK ORDER CHANG	GES		·					
DATE	STEP	PRO	Ву	C	ate Qt	y Approval Chief Eng / Prod Mgr	Approval QC Inspector					
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NCR:		•	WORK ORDER NON-CONFORMANCE (NCR)									
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DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng		gn & ate	Section C	Chief Eng	QC Inspector			
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DART AEROSPACE LTD	Work Order:	41662
Description: Float Skidtube (412)	Part Number:	D3391-1
Inspection Dwg: D3391 Rev: H		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

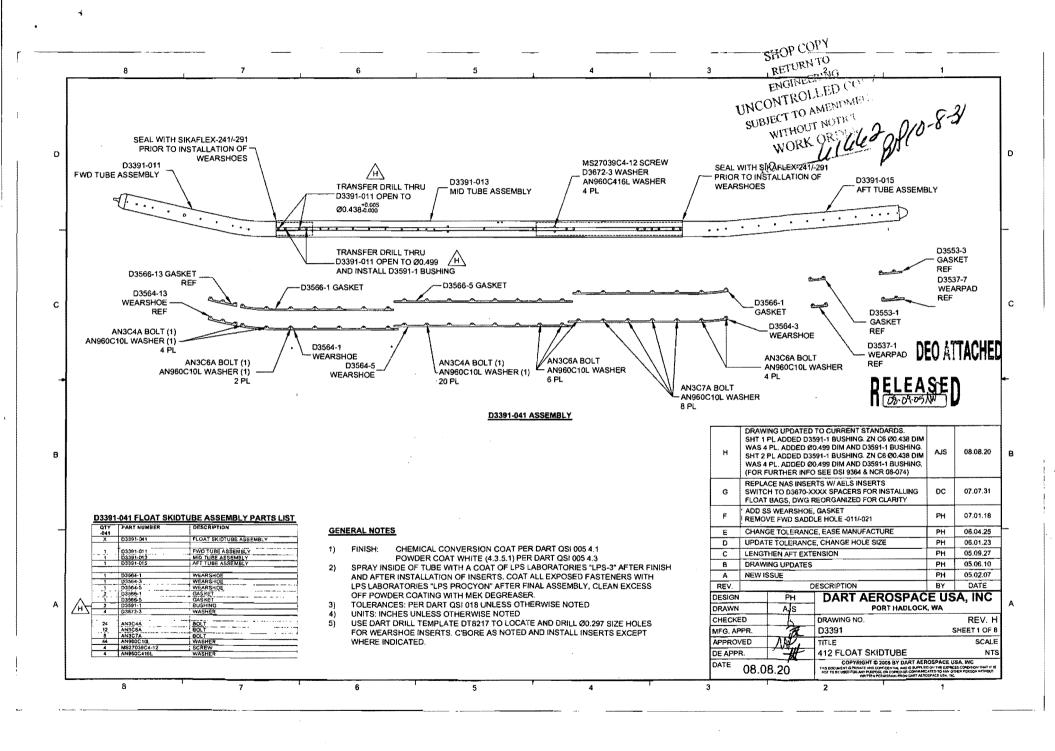
XF	First Article		Prototype
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Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.687	+0.010/-0.000	-690				
3.590	+0.025/-0.010	3,615				
3.300	+0.040/-0.000	3 320				
1.429	+0.040/-0.060	1.420				
4.250	+/-0.010	4.236				
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Meaşured by:	48	76	Audited by:	ント	Prototype Approval:	N/A
Date:	10/10/1	4	Date:	10/11/22	Date:	N/A

Date	Change	Revised by App	proved
06.04.27	New Issue P/O D3391-011/-021	KJ/JLM	
06.06.19	Tolerances revised per D3391 Rev. E	KJ/JLM	
07.03.21	Dimensions removed per Dwg rev. F	KJ/JLM	
07.11.23	Dwg Rev. updated	KJ/EC/DD	
09.12.14	Dwg Rev updated	KJ 95- 1	7
	06.06.19 07.03.21 07.11.23	06.04.27         New Issue         P/O D3391-011/-021           06.06.19         Tolerances revised per D3391 Rev. E           07.03.21         Dimensions removed per Dwg rev. F           07.11.23         Dwg Rev. updated	06.04.27         New Issue         P/O D3391-011/-021         KJ/JLM           06.06.19         Tolerances revised per D3391 Rev. E         KJ/JLM           07.03.21         Dimensions removed per Dwg rev. F         KJ/JLM           07.11.23         Dwg Rev. updated         KJ/EC/DD

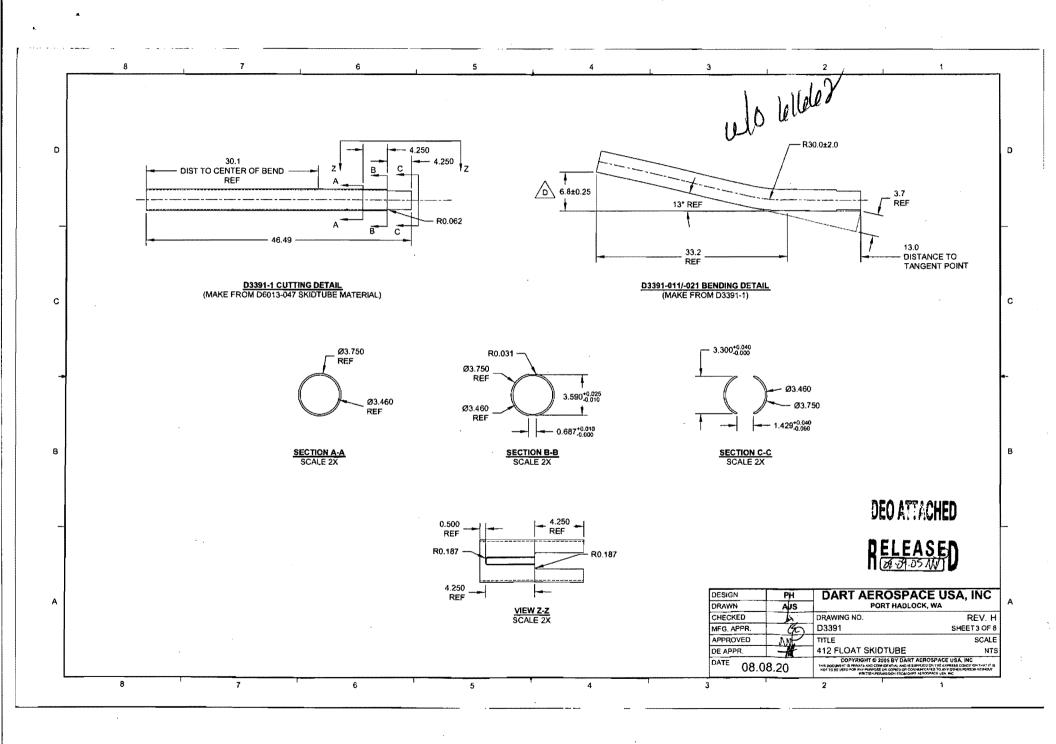
W/O:	<u> </u>		WC	ORK ORDER CHANG	GES				•	
DATE	STEP	PR	OCEDURE CHAI	NGE	В	у	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	jory:	_ NCR: `	es N	lo DQ	<b>A:</b>	Date:	
	Re	solution:	Disposition	n:	QA: N/	C Clo	sed:		Date:	
NCR:		,	WORK ORDE	R NON-CONFORM	ANCE (I	ICR)	ı			
DATE	STEP Description of NC		Corrective Action		tion B	ign &	Verific		Approval	Approval
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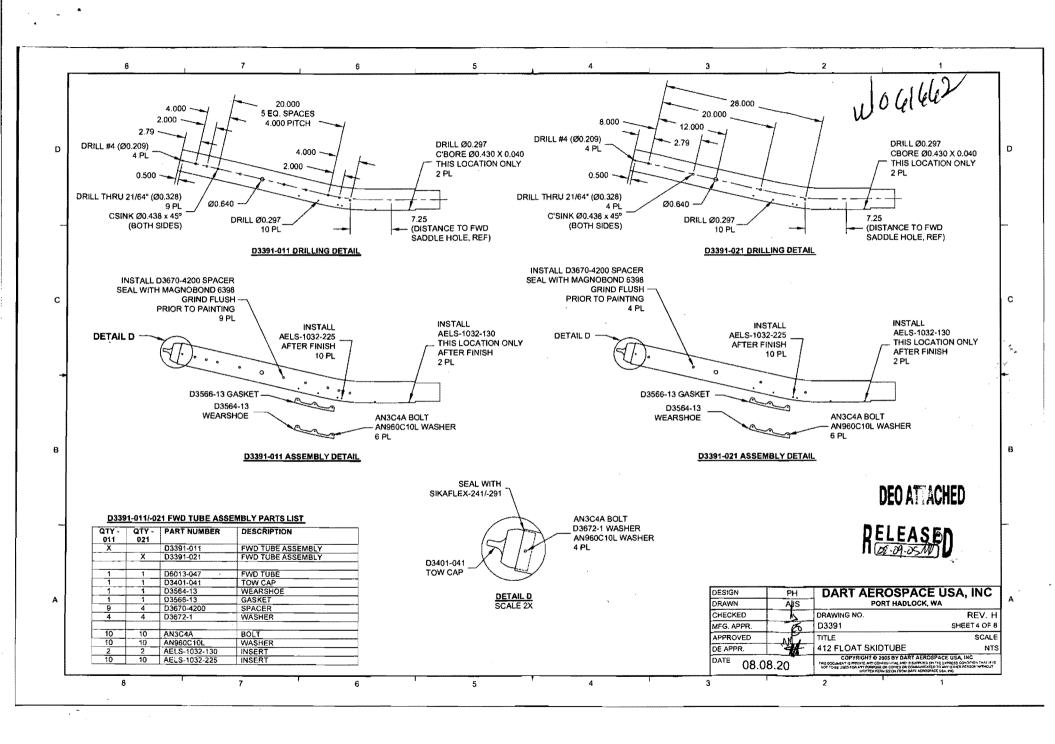
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while leter D SEAL WITH SIKAFLEX-241/-291 PRIOR TO INSTALLATION OF WEARSHOES D3391-021 SEAL WITH SIKAFLEX-241/-291 FWD TUBE ASSEMBLY PRIOR TO INSTALLATION OF D3391-025 D3391-023 TRANSFER DRILL THRU WEARSHOES AFT TUBE ASSEMBLY MID TUBE ASSEMBLY D3391-021 OPEN TO Ø0 438-0 000 TRANSFER DRILL THRU D3553-3 С D3391-021 OPEN TO Ø0.499 GASKET , AND INSTALL D3591-1 BUSHING REF D3566-13 GASKET D3566-5 GASKET D3566-1 GASKET D3564-13 D3537-7 WEARSHOE D3566-1 WEARPAD D3553-1 REF GASKET REF GASKET D3564-3 REF AN3C4A BOLT WEARSHOE D3537-1 AN960C10L WASHER D3564-1 4 PL WEARPAD WEARSHOE AN3C6A BOLT AN3C6A BOLT AN3C6A BOLT REF AN960C10L WASHER D3564-5 AN960C10L WASHER AN3C4A BOLT AN960C10L WASHER 4 PL WEARSHOE AN960C10L WASHER 2 PL 6 PL AN3C7A BOLT AN960C10L WASHER **D3391-043 ASSEMBLY** D3391-043 FLOAT SKIDTUBE ASSEMBLY PARTS LIST DEO ATTACHED **GENERAL NOTES** DESCRIPTION CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3 SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER. TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED UNITS: INCHES UNLESS OTHERWISE NOTED USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL Ø0,297 SIZE HOLES DESIGN DART AEROSPACE USA, INC FOR WEARSHOE INSERTS, C'BORE AS NOTED AND INSTALL INSERTS EXCEPT WHERE INDICATED. DRAWN PORT HADLOCK, WA CHECKED DRAWING NO. REV. H MFG. APPR. D3391 SHEET 2 OF 8 APPROVED SCALE TITLE DE APPR. 412 FLOAT SKIDTUBE NTS THE DOCUMENT OF THE PROPERTY O 08.08.20

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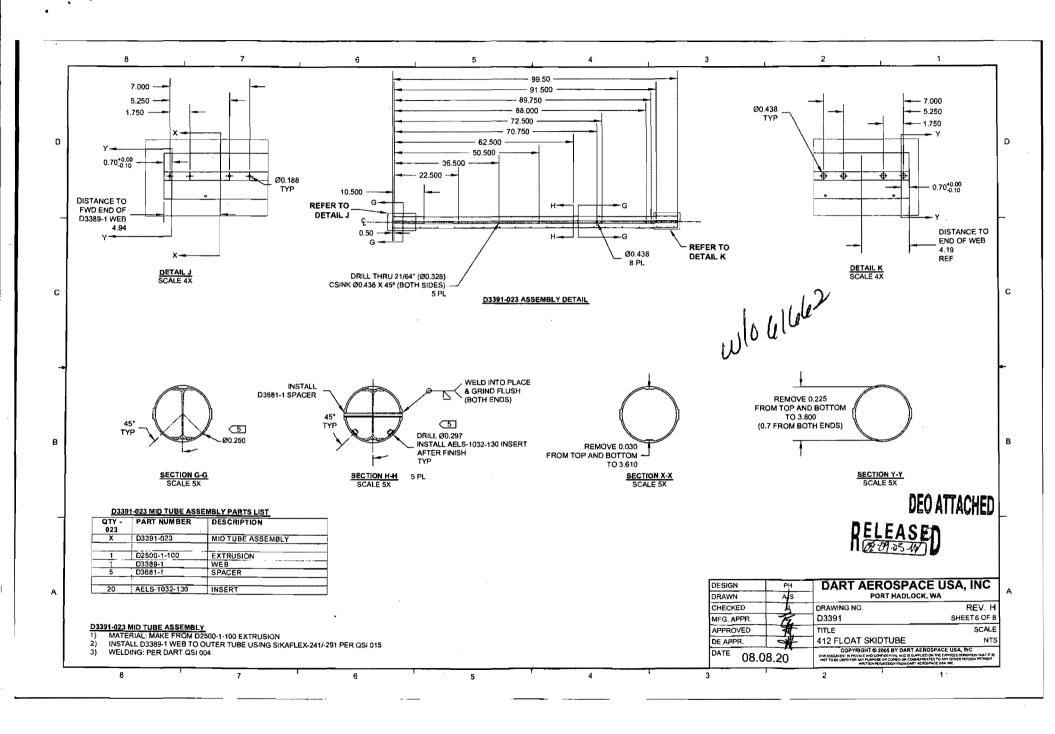
7 8 6 7.000 --5.250 -- 7.000 1.750 -Ø0.438 -- 5.250 TYP 1.750 34.500 70.750 10.500 12.500 000 750 D Đ 89.0 0.70+0.00 22.500 26.500 30.500 Ø0 188 0.70+0.00 TYP REFER TO DISTANCE TO **DETAIL K** FWD END OF D3389-1 WEB REFER TO & 4.94 DETAIL J DISTANCE TO END OF WEB 4.19 Ø0.438 REF **DETAIL E** 8 PL DRILL THRU 21/64" (Ø0.328) DETAIL K SCALE 4X DETAIL J SCALE 4X D3391-013 ASSEMBLY DETAIL CSINK Ø0.438 X 45° (BOTH SIDES) С C WELD INTO PLACE & GRIND FLUSH INSTALL **D3681-1 SPACER** (BOTH ENDS) REMOVE 0.225 FROM TOP AND BOTTOM 45° TO 3.800 TYP (0.7 FROM BOTH ENDS) DRILL Ø0.297 INSTALL AELS-1032-130 INSERT REMOVE 0.030 AFTER FINISH FROM TOP AND BOTTOM -TYP TO 3.610 SECTION H-H 12 PL SCALE 5X SECTION X-X SCALE 5X DRILL Ø0.297 SCALE 5X INSTALL AELS-1032-130 INSERT MS27039C1-09 SCREW D3672-1 WASHER 26.00 AN960C10L WASHER AFTER FINISH - 0.930 4 PL D3391-013 MID TUBE ASSEMBLY PARTS LIST 53° TYP PART NUMBER DESCRIPTION -013 D3391-013 MID TUBE ASSEMBLY D2500-1-100 EXTRUSION D3389-1 WEB - 12.25 D3672-1 DRILL Ø0.250 WASHER SCALE 5X SECTION LL-LL D3672-3 D3681-1 WASHER DETAIL E SCALE NONE DEO ATTACHED 18° INSERT AELS-1032-130 (TYP) ALS4-428-165 INSERT AN960C10L WASHER DART AEROSPACE USA, INC DESIGN AN960C416L WASHER DRAWN PORT HADLOCK, WA MS27039C1-09 MS27039C4-08 DRILL Ø0.391 INSTALL ALS4-428-165 INSERT CHECKED DRAWING NO. REV. H MS27039C4-08 SCREW D3391 SHEET 5 OF 8 MFG. APPR. **D3672-3 WASHER** APPROVED 1) MATERIAL: MAKE FROM D2500-1-100 EXTRUSION TITLE SCALE AN960C416L WASHER 412 FLOAT SKIDTUBE DE APPR. NTS AFTER FINISH INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/-291 PER QSI 015 4 PL COPYRIGHT © 2005 BY DART AEROSPACE USA, INC

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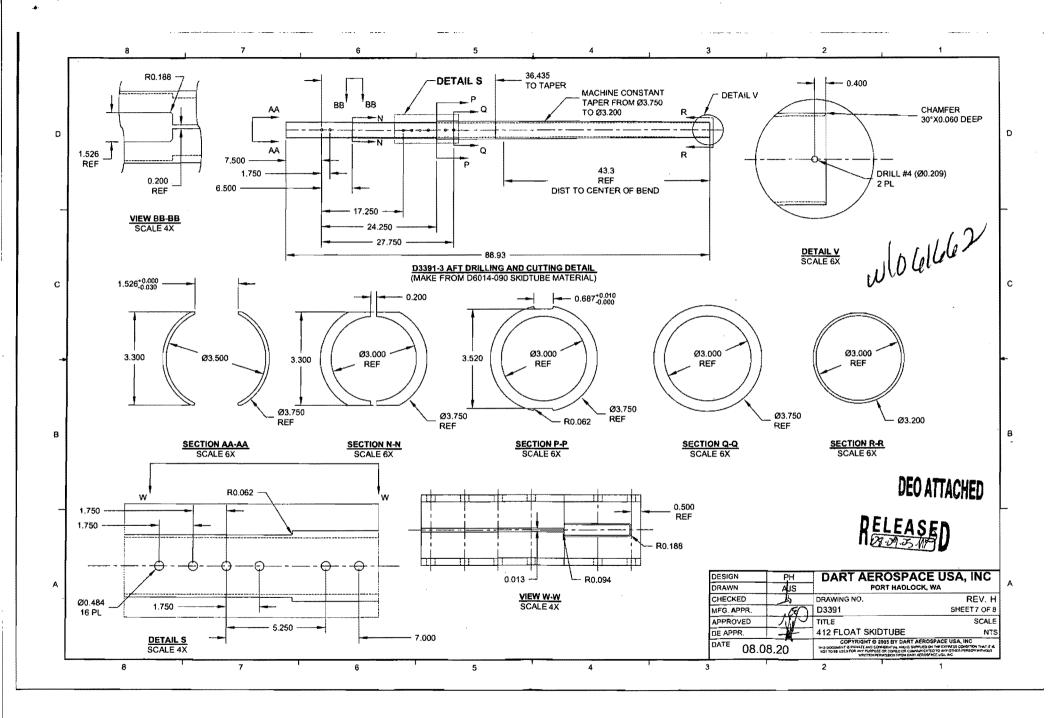
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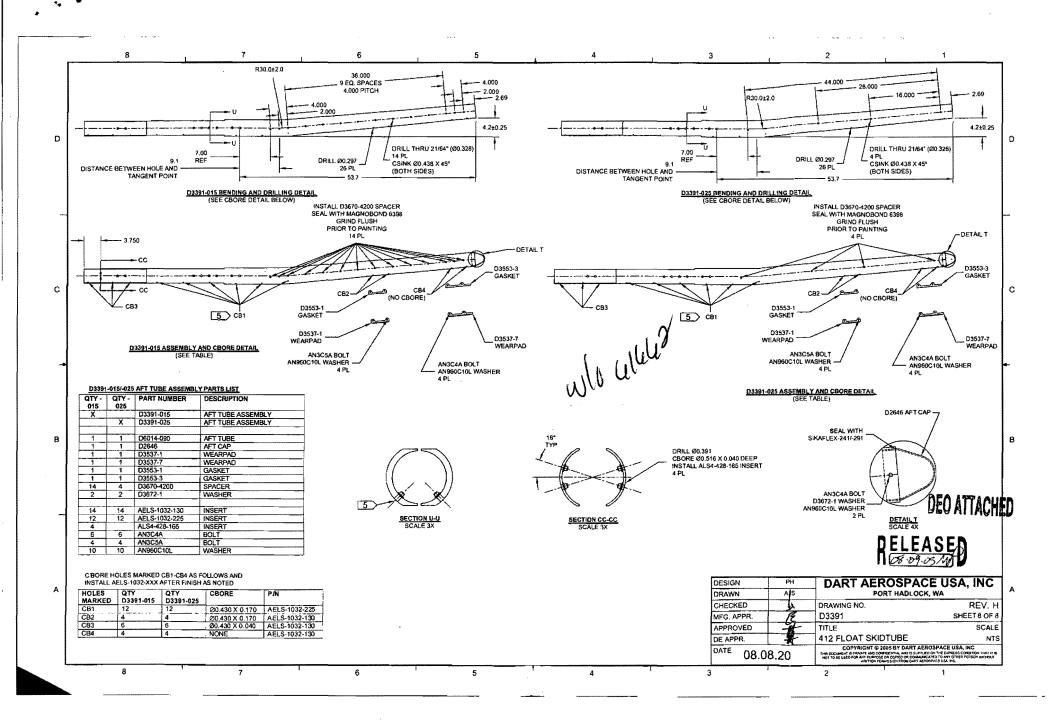
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#### **PURPOSE:**

LPS-3 IS NO LONGER USED DURING ASSEMBLY OF D3391-041/-043 SKIDTUBES.

#### **CHANGE:**

AMEND NOTE 2 OF D3391-041/-043 SKIDTUBE ASSEMBLIES (ZN A6-1, A6-2) AS FOLLOWS:

2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

RELEASED 2010 -02- 0 2

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